Mitsubishi Engineering-Plastics Corp.

Iupilon™ KH3310UR

Mitsubishi Engineering-Plastics Corp - Polycarbonate

General Information	
Product Description	
High Surface hardness (Clear), Pencil Hardness H	
General	
Features	• High Hardness
Uses	• General Purpose

ASTM & ISO Properties [1]

Physical	Nominal Value	Unit	Test Method
Density	1.17	g/cm³	ISO 1183
Melt Mass-Flow Rate (MFR) (300°C/1.2 kg)	35	g/10 min	ISO 1133
Melt Volume-Flow Rate (MVR) (300°C/1.2 kg)	33	cm³/10min	ISO 1133
Molding Shrinkage			Internal Method
Across Flow	0.50 to 0.70	%	
Flow	0.50 to 0.70	%	
Water Absorption (24 hr, 23°C)	0.20	%	Internal Method
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	2700	MPa	ISO 527-1/1
Tensile Stress (Yield)	74.0	MPa	ISO 527-2/50
Tensile Strain			ISO 527-2/50
Yield	6.0	%	
Break	85	%	
Flexural Modulus [2]	2600	MPa	ISO 178
Flexural Stress [2]	106	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	3.0	kJ/m²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load			
0.45 MPa, Unannealed	117	°C	ISO 75-2/B
1.8 MPa, Unannealed	105	°C	ISO 75-2/A
CLTE			ISO 11359-2
Flow	6.5E-5	cm/cm/°C	
Transverse	6.7E-5	cm/cm/°C	
Flammability	**Nominal Value**	**Unit**	**Test Method**
Flame Rating (0.40 mm)	V-2		UL 94

Iupilon™ KH3310UR

Mitsubishi Engineering-Plastics Corp - Polycarbonate

Processing Information		
Injection	**Nominal Value**	**Unit**
Drying Temperature - Hot Air Dryer	100	°C
Drying Time - Hot Air Dryer	4.0 to 8.0	hr
Rear Temperature	250 to 300	°C
Middle Temperature	250 to 300	°C
Front Temperature	250 to 300	°C
Nozzle Temperature	250 to 300	°C
Mold Temperature	60 to 100	°C